

Date: Wednesday, 6/27/2007 1:08:27 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: NUT
Job Number	: 33223		
Estimate Number	: 11087		
P.O. Number	: N/A	Part Number	: D31763
This Issue	: 6/27/2007 S.O. No. : N/A	Drawing Number	: D3176 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: A
Previous Run	: 25029	Material	: N/A
Written By	:	Due Date	: 7/20/2007
Checked & Approved By	:	Qty:	4 Um: Each
Comment	: Est Rev:B Removed -1 05-11-29 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M303R1000	303 Round Bar 1.0"
		Comment: Qty.: 0.0525 f(s)/Unit Total : 0.2100 f(s) Material: AISI 303 SS 1.00 round bar Ref: Dart Spec: M303R1.000 Batch: M18429 * 0.3150 f(s) used But in comp. only 0.0006 left <i>DSP 07/07/07</i> (6)
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
		Comment: HARDINGE CNC LATHE SMALL 1-Turn as per Folio FA287 & DWG D3176 <i>DSP 07/07/07</i> (6)
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>DSP 07/07/07</i> (6)
4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
		Comment: CONVENTIONAL MILLING MACHINE 1- Mill flats as per dwg D3176 <i>DSP 07/07/07</i> (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/07/12  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: NUT

Job Number: 33223

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Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



*DSR 07/07/08*

(6)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

6.0 QC8

SECOND CHECK



Comment: SECOND CHECK

*MK 07/07/08*

6

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*E. Dyer Jr. (6)*

8.0 QC21

FINAL INSPECTION/W/O RELEASE



*(6) 07/07/08*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*J. 07/07/12*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	33223
Description: Nut	Part Number:	D3176-3
Inspection Dwg: D3176 Rev: A		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

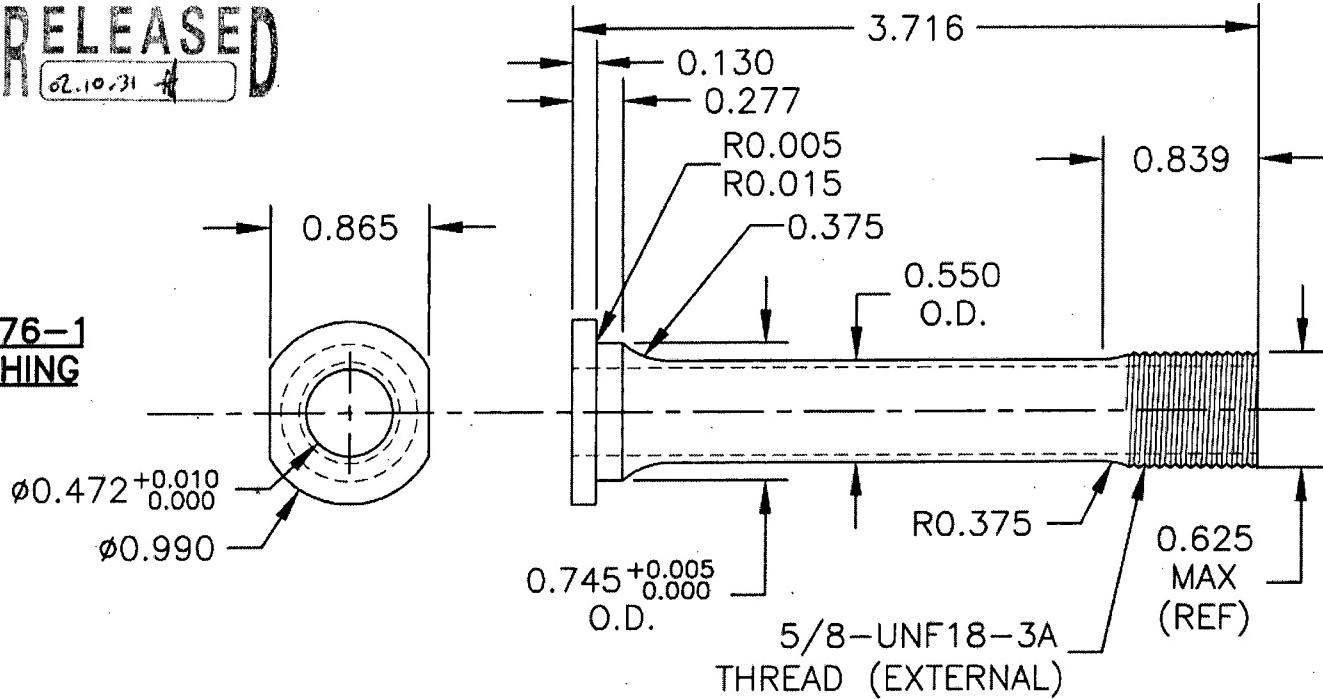
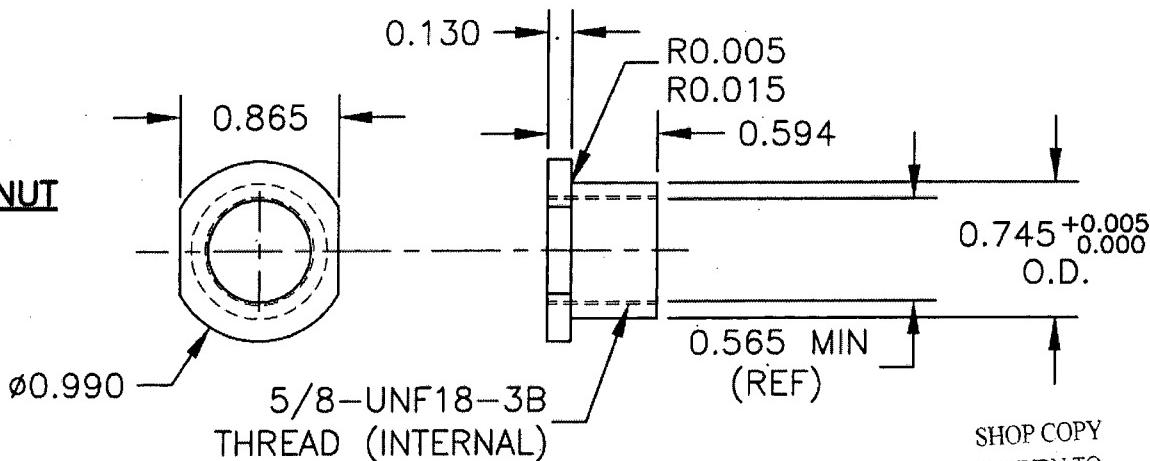
## X First Article      Prototype

Measured by:	DJP	Audited by:	JNL	Prototype Approval:	N/A
Date:	07/07/07	Date:	07/07/08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.12	New Issue	KJ/RF	JF

**DART**

DESIGN <i>KP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>AS</i>	APPROVED <i>AS</i>	DRAWING NO. D3176	REV. A SHEET 1 OF 1
DATE 02.10.28		TITLE BUSHING / NUT	SCALE 1:1
A	02.10.28	NEW ISSUE	

**RELEASED**  
(02.10.31)**D3176-1  
BUSHING****D3176-3 NUT****D3176-1/-3**

- 1) MATERIAL: AISI 303 S.S. (REF DART SPEC. M303R1.000)
  - 2) THREADS PER MIL-S-7742
  - 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
  - 4) FINISH: NONE
  - 5) ALL DIMENSIONS ARE IN INCHES
  - 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 7) D3176-1/-3 ARE MATING PARTS
- SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 33223

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